Work Order Qctober-24-12 10:			*921	58*				Page 1	
Revision ID: Item Name: Co	412-704-011 pilot Emergency Cargo Release 2/23/12	*2* *2*	Accept PASTIVE RECULL	*N9000 Cust Item II Customer:		7* Set	up Start Stop	*NS1* *NS2*	
Approvals: P	Process Plan: <u></u> <u> </u>				te:	Rui	n Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code			eject Insp. Imber Stamp	
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		Inspection	Strip in	Tube		Cut Too Short		Misread	I		Power Loss/:	Surge	Other		
		Ripples in	Bend			Drill Holes	<u> </u>	Offset							
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QC21- Final Inspection - Work Order Release

Memo

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140 QC

Quality Control

12/12/20 12-11-29

Insp.

Page 2

											DQA:	Dat	e: ,	
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Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Picklist Print Page 1 October-24-12 10:18:40 AM 92158 Work Order ID: Required Date: 11/09/12 **Start Date:** 10/23/12 D412-704-011 Parent Item: Start Oty: 2.00 Required Oty: 2.00 Copilot Emergency Cargo Release Parent Item Name: IPP Rev:B05.01.28Hardware added to Step 3KJ/RF Comments: IPP Rev:C05.12.21Hardware removed on Step 3 EC IPP REV:D AS PER REV C JLM **VERIFIED BY:EC** IPP REV:E 12.05.10 per ECN 12-583 DD verf:EC Qty per Kit Total Last Unit of Qty on Qty Date Status Component Item ID/ Replacement Mfg/ Bin **Primary** Route Measure Hand Item Name Location Seq ID Qty Issued Issued Item ID Item Location Purch 2.0000 D412-704-041---No 110 Each 2 Manufactured Pedal Assembly (205/212/214/412) Loc Code Loc Qty Location ST203 2 2 85954 110 4.0000 D412-704-045 No Each Manufactured Cable Assembly (212/214/412) Loc Qty Loc Code Location ST223 87383 87383 110 16.0000 Each --- D3207-5-No Manufactured Bracket Location Loc Qty Loc Code 10 ST 10 85999 ST202 70293 85994 110 Each 6.0000 D3207-7 No Manufactured Packer Loc Qty Loc Code Location ST202 82198 82198 6 5.0000 D3207-11 No 110 Each Manufactured Bracket Loc Qty Loc Code Location ST202 5 5 86783

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		Cracks				Broken/Damaged	L	4 .	on Incomplete		Part Incorred	:t	Weld	
		Crushed/C	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Treat	t			Countersink		Mislabe	led		Positioned V	/rong		
		Inspection	Strip in	Tube		Cut Too Short	<u></u>	Misread	İ		Power Loss/	Surge	Other	
[Ripples in	Bend			Drill Holes	L	Offset						
		Torque W	aves in E	xtrusior	1	Drawing		Out of C	Calibration					
		Turning Se	equence			Finish		Out of S	equence					
		Wave/Twi	ist in Tub	e	1	Folio		Outside Dimensions						

DQA: _____ Date: ___

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Picklist Print October-24-12 10:										Page 2
Work Order ID: Parent Item: Parent Item Name:	92158 D412-704-011 Copilot Emergenc	y Cargo Release						art Date: 10/23/12		Required Date: 11/09/12 Required Qty: 2.00
D3208-1		Manufactured	No		110	Each	15.0000		2	18
Doubler	SM) of			Location ST202	<u>Loc Qty</u>		Loc Code			The second second
D3208-11		Manufactured	No	83920 88310	7 8 110	Each	5.0000	8392		~ 1 B &
Filler	m sp			<u>Location</u> ST202	Loc Oty 5		Loc Code			The state of the s
D3208-3 Pedal Mount Angle	<i>A</i> .	Manufactured	No	82201 86642	3 2 110	Each	11.0000	8664	2	JB S
Spl-))			Location ST202 85947 86002	<u>Loc Oty</u> 11 5		Loc Code	8600	- 1	•
D3208 ₌7. Filler	∩ .→	Manufactured	No	80002	110	Each	16.0000		2	JB S
5p7	0 21			Location ST202 83918	<u>Loc Oty</u> 16 16		Loc Code	83918	5 -	•
D3208-9	\rightarrow	Manufactured	No		110	Each	18.0000		2	73 12/11/3
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				ST202 83940	2 2			83940	7	•
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WOIR Olde					 .	Rework	٦		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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Hardware

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

October-24-12 10:18:41 AM

Work Order ID:

92158

Parent Item:

D412-704-011

Parent Item Name:

Copilot Emergency Cargo Release

Manufactured

Purchased

No

No

Start Date: 10/23/12

Required Date: 11/09/12

Start-Qty: 2.00

Required Qty: 2.00

Placard

Location .

GA

110

Loc Qty

Each

16.0000

Loc Code

2

MS21919-DG5

Clamp

2

86845 ST202 83919

110

Each

69.0000

83919

Loc Code Loc Oty Location 19 ST306 119638 6×120731 18 120731 ST321 50 24 122807 50 122807

NCR: Y	'es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPDAT	ΓE			
					· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date	:: ,
Work Orde	r.				DISPOSITION			ı	AGAINST DE	PARTMENT	/PROCESS	
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Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector
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	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped. t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabel Misread Offset	on Incomplete ions Incomplete/Uncle nance led	ear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i	Torque W	'aves in E	xtrusion	1	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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ICA-D412-704 Page 19 of 20

25.4 PARTS LIST

Sty	Qty	Qty	Qty	Qty	Qty	Qty		
-011	-013	-015	-041	-141	-043	-045	Part Number	Description
Х							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	Х						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		Х					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
4=			=x=				=D412-704-041	=PEDAL-ASSEMBLY (205/210/212/214)
		1		Х			D412-704-141	PEDAL ASSEMBLY (412)~
	1				Х		D205-704-043	CABLE ASSEMBLY (205)
=		=1=				X	_D412-704-045	=:CABLE:ASSEMBLY-(210/212/214/412)
		ļ						DEDAL ACCEMBLY (OD FOM COOTOO 4)
L			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
$\vdash \vdash \vdash$			1	1	ļ		D3205-1	PEDAL BRACKET (OR ECM 999703-1)
<u> </u>			1	1	ļ		D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1	ļ	L	D3206-1	PEDAL ARM (OR ECM 999704-1)
$\vdash \vdash \vdash$	1				-		D3207-1	BRACKET
	1	<u> </u>					D3207-3	BRACKET
		1					-D3207-5	BRACKET /
	1	_1_	·				_D3207-7	PACKER
		1					D3207-9	BRACKET
<===							-D3207-11	BRACKET
4=	1_	<u>=1=</u>					_D3208-1	DQUBLER=(@R:EGM-999709-1)
		1					-D3208=1:1	= FitteR
4==	==1==	=1=					=D3208-3=====	EPEDALMOUNTANGLE=(OR*ECM*999709-7)
	1	L					D3208-5	MOUNT ANGLE
<u>-1=</u>	===	===	-				-D3208-7-	= =FIEEER=(OR:ECM:999709=3)
~ =		=1==					_D3208-9	_DOUBLER
			1	1		,	D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
4		 7					D3214=1	=PEACARD=(OR=EGM-9997-12-1)
					1		D3217-1	CABLE
	-					1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1			1		D4610-3	DOUBLER
	1		1	1			D4610-5	SHIM
	Ī	1			1		D4610-7	COVER
				1			D4611-1	BUSHING
	<u> </u>	1			1		D4622-1	PLACARD
		1					D4622-3	PLACARD
						L		
			1	1			AN3-10A	BOLT
				T	1	1	AN3-13A	BOLT
		1	1	1			AN315-4R	NUT
		ļ			1	1	AN3-5A	BOLT
		1	2	2			AN3-6A	BOLT
	†	l –	1 1	1 1		1	AN4-10A	BOLT
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ICA-D412-704 Page 20 of 20

[Sty]	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
=4=	 4=	= 4=		===		===	=MS21919DG5====	=CLAMP=====
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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